

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006151**Date Inspected:** 07-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shi Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Dan Hernandez was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 13 OBG Assembly

Segment 1BW

Shielded Metal Arc Welding (SMAW) of weld joint CA95-071 thru 076 located on Segment Corner Assembly. Welder is identified as 066481. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 2AW

Shielded Metal Arc Welding (SMAW) of weld joint SEG007F-060, 061, 064, 065, 066, 067 located on Segment Corner Assembly. Welder is identified as 066482. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 6CE

Shielded Metal Arc Welding (SMAW) of weld joint CA30-004 located on Segment Corner Assembly. Welder is

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identified as 066481. ZPMC QC is identified as Zhong Guo Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector performed Ultrasonic Testing (UT) of approximately 10% of Complete Joint Penetration (CJP) welds previously tested and accepted by ZPMC Quality Control personnel. The weld designations are as follows:

Segment 2BW

SSD14-PP17-002, 003, 009

SSD14A-PP17-007, 003

SSD13-PP18-002, 003, 134

SSD13A-PP18-002, 003, 009, 138

SEG009A-004, 005, 006

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
